

STAR Technology

FORMULATING • INNOVATIVE • SOLUTIONS

230-05

Fast Cure Urethane

DESCRIPTION

STAR- Technology 230-05 is a filled, rapid cure casting systems for applications up to 150°F. When determining the maximum depth of a pour, factors to appraise include the configuration of the cast and the thermal conductance of the master. 230-05 may be cast up to 3 inches deep. Typical applications for 230-05 include bonding, fixturing, low temp vacuum form molds, fast cast tooling base and pattern back-up material.

BENEFITS

Accurate reproduction of detail	Excellent machinability
May be cast over 3" thick	Very Fast Turn Around Time

TYPICAL PROPERTIES

		<u>TEST METHOD</u>	<u>VALUE</u>
Mix Ratio, Resin to Hardener	Parts by Weight		100:130
	Parts by Volume		100:100
Mixed Viscosity (centipoise)		ASTM D2393	9,000
Density (lbs./cu.ft.)		ASTM D1475	118
(lbs./gal.)			15.71
Pot Life at 75°F (minutes)		ASTM D2471	15
Color			Tan to Gray
Exotherm at 3" thick casting:			229°F
Shore Hardness (D)		ASTM D2240	82 D
Tensile Strength (psi)		ASTM D638	1,400 psi
Flexural Strength (psi)		ASTM D790	3,800 psi
Flexural Modulus (psi)		ASTM D790	278,000 psi
Compressive Ultimate Strength (psi)		ASTM D695	7,300 psi
Shrinkage (%)			Nil
Coeff or exp. (in/in/°c)			3.2E-5
Glass Transition Temperature (°F)		By DSC	127°F
Maximum Service Temperature (°F)			250°F
Demold Time:			60 minutes

APPLICATION PROCEDURE

Carefully weigh out appropriate amounts of resin and hardener into a clean container and mix until all streaks are gone. Scrape the sides and bottom frequently to ensure complete mixing. Pour the mixed material in the thinnest stream possible onto a single spot of the mold cavity. Allow the mixture to flow over the mold surface to help eliminate air entrapment.

To the best of our knowledge, the information contained herein is accurate. However, STAR TECHNOLOGY, Inc., does not assume any liability whatsoever for the accuracy or completeness of the information contained herein. Final determination of the suitability of any material is the sole responsibility of the user. The information contained herein is considered typical properties and is not intended to be used as specifications for our products. This information is offered solely to assist purchaser in selecting the appropriate products for purchaser's own testing. All materials may present unknown hazards and should be used with caution. Although certain hazards are described herein and in the material safety data sheet, we cannot guarantee that these are the only hazards that exist. Repeated and prolonged exposure to epoxy resins can cause sensitization or other allergic responses.

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NOTE: To obtain optimum service temperature follow the suggested curing schedule with thermocouple monitoring. Thermocouple monitoring equipment is recommended on all post cured tools. High temperature tools should be post cured prior to use. High temperature tools should be cured 50°F beyond anticipated use temperature.

CAUTION: Unmixed material from the sides or bottom of the container can cause soft spots or uncured areas in the completed tool. To prevent this, transfer the entire mixed contents to a second clean container and re-mix for a short time before using.

Additional Cure Schedule - If thermocouple monitoring equipment is not available then a longer step cure is a better choice, e.g.

*2 hours @ 150°F + 2 hours @ 200°F +
2 hours @ 250°F + 2 hours @ 300°F +
2 hours @ 350°F*

SAFETY PRECAUTIONS

For industrial use only. Keep away from children.

Refer to the Safety Data Sheets (SDS forms) pertaining to this product before using.

Avoid contact with skin or eyes. In the event of an eye splash or contact, immediately flush with cold water for 15 minutes and contact a physician. If skin contact occurs, wash with mild soap and water. The wearing of safety glasses with side shields and impervious gloves is recommended.

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